



Number: (Twin) 11/71
Subject: Piston Ring
Replacement
Models: 'B' Range
Date: Sept. 20, 1971

SERVICE BULLETIN

of TRIUMPH MOTORCYCLES INCORPORATED

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CP208 - CD460 PISTON RING REPLACEMENT

To accomplish a good ring job, it is essential that the component parts be properly inspected and prepared. The following instructions are guidelines for doing a proper ring job:

CYLINDER

The cylinder must be checked for wear. The largest amount of wear will be found at a point approximately 1/2 to 3/4 inch down the bore and at 90° to the wrist pin. To measure wear, first establish a measurement at the bottom of the bore where there is little or no wear, then measure at a point about 1/2 inch down from the top of the bore. If there is more than .005 inch difference between the top and bottom measurement, the cylinder must be rebored. If the wear is not excessive, the cylinder can be honed. The honing should be done with a 150-grit stone using an up-and-down motion until a crisscross pattern is achieved. After honing is finished, thoroughly clean abrasives from cylinder.

PISTONS

Clean carbon from piston and inspect for damage such as scuffing and ring land wear. The side clearance between the ring groove and a new ring should not exceed .005 inch. Check with a feeler gauge. Check wrist pin fit—the wrist pin should slip into the piston at room temperature with very slight pressure. If a hammer and drift are required to fit the wrist pin, it is too tight and the piston should be honed to give the proper slip fit.

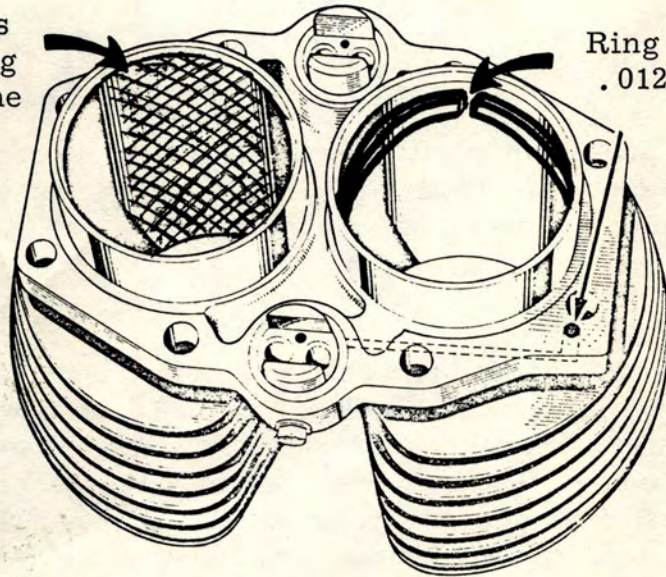
RING END GAP

Check piston ring end gap by inserting the new ring in the lower portion

(Over)

of the bore. Then measure end gap with a feeler gauge. The correct end gap is .012 to .018 inch. After the end gap has been checked, install the rings on the piston. Stagger the rings so the end gaps are at 120° to each other. Apply a small amount of oil to piston and cylinder bore prior to assembly. If these instructions are followed, rings will seat in very few miles, thus eliminating oil consumption.

Crisscross
Pattern using
150 Grit Hone



Ring End Gap
.012 - .018

Check Ring Grooves
For Proper Clearance

